



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3913-041
Job Sheet 179317



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Large Fab-5		<i>2 M.L. 18-6-26</i>
100	Large Fab	1 pcs	7/31/18	7/31/18	0.00	10.00	Large Fab 1		<i>CP 18-6-26</i>
110	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC9		<i>24 2018-06-26</i>
120	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC5		<i>24 2018-06-26</i>
125	HandFinish	1 pcs	7/31/18	7/31/18	0.00	0.29	HandFinish2		<i>24 18-7-9</i>
130	Powdercoat	1 pcs	7/31/18	7/31/18	0.00	0.93	Powdercoat2		<i>24 18-7-9</i>
135	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging1		<i>24 18-7-9</i>
140	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC3		<i>24 18-7-9</i>
150	HandFinish	1 pcs	7/31/18	7/31/18	0.00	0.50	HandFinish4		<i>24 18-7-9</i>
160	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC5		<i>24 18-7-10</i>
170	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		<i>24 18-7-10</i>
180	QC21-SA	1 Ea	7/31/18	7/31/18	0.00	0.00	QC21		<i>21 JUL 10 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138834 START: 11:40. ON T. 375° FINISH: 11:55.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>5068733</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5082948</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>5059261</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5061952</i>
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5079285</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>5066247</i>
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	<i>5077122</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>5079007</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>5074862</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>5058574</i>
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5067578</i>
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	

M. U. 004094

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																									

D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5070373
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5076135
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5076130
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	50549363
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5060244
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5078251
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007-L
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5078252
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	507145
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5067457

Job Allocations

004289

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	75	0
	D3913-1	1	2	0
	D3913-15	1	12	0
	D3913-3	1	13	0
	D3913-7	2	24	0
	D3913-9	1	6	0
	D3916-041	2	14	0
	D3916-5	3	13	0
	D4016-1	3	25	0
	D4017-7	3	57	0
	D4017-9	2	12	0
	D4020-11	2	13	0
	D4021-1	3	52	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	22	0
	M304EX0.75-16F	33	1,310	0
150-HandFinish	AN3-10A	6	180	0
	D2931	2	1,018	0
	D4021-5	2	40	0
	MS20600-AD4W3	2	405	0
	MS21042L3	6	1,544	0
	NAS1149F0332P	12	1,710	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
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Container No: S084363
Part: D3913 - 041
Job No: 179317
Serial No/Batch: S084363
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 06/28/18

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